



Dart Aerospace Ltd.
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D3914-041
Job Sheet 202040



Part No: D3914-041

Job Qty: 1 pcs

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/18/19

Job Tracking No:

Due Date: 11/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	11/15/19	11/15/19	0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	11/15/19	11/15/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	11/15/19	11/15/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		

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Container No: S226292



Part: D3914-041

Job No: 202040

Serial No/Batch: S226292

Revision: A/D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/26/19

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						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	EL
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
130 Powdercoat - 4 Black Sand - B4B	1 pcs	11/15/19	0.00	0.40		Powdercoat - 1 - B4B	
M156440- START: 1:00 O.V.T. 3:00 FINISH: 1:30						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BL 19-11-01
						Powdercoat - 4 - B4B	
135 QC 3	1 pcs	11/15/19	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	1/2 19-11-01
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
140 Handfinish - 3-1- WingWalk- B4B	1 pcs	11/15/19	0.00	0.80		Handfinish - 3 - 1 - B4B	1/2 19-11-01
						Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
150 QC 3	1 pcs	11/15/19	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	

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[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 QC 21 - SA	1	11/15/19	0.00	0.00	QC 21 - SA - 21	
	pcs				QC 21 - SA - 70	
					QC 21 - SA - 53	

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Part Op 100 - (Weld per dwg A/R S.S. rod Batch: 139015 - assemble ribs , weld as per dwg D3914 using DT9607A 2- weld Descriptions: hinge (3) and Mounting brackets as per dwg D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh***

110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

130 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 *** mask sides of hinge prior to powdercoat***

135 - QC3- Inspect Part Finish

140 - Wing Walk as per dwg QSI005 4.4 Batch _____ 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock Location: _____

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5211240
D3914-1	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5222855
D3914-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5221681
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	100-Large Fab - Basket - 1	2x 5193147
D4018-5	Rib	9 pcs (9 ea)	100-Large Fab - Basket - 1	5219005
D4020-5	Mesh (350 Basket Long, Lid)	1 pcs (1 ea)	100-Large Fab - Basket - 1	5172001
D4021-3	Data Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5219016
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	100-Large Fab - Basket - 1	5221529

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	97	0
	D3914-1	2	14	0
	D3914-7	2	14	0
	D4016-3	3	165	0
	D4018-5	9	92	0
	D4020-5	1	6	0
	D4021-3	1	11	0
	D4035-043	2	8	0

Part Specifications

Specifications could not be found.

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____		DISPOSITION		DEPARTMENT/PROCESS				Engineering											
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Water Jet ☐ Supplier ☐ Quality ☐									
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)													
Description Work Order Deviation				Disposition															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
				Other/Details: _____															
				Completed By				Lead hand / Supervisor											
								QC / QA Coordinator											